

Work Order ID 73305

Wednesday, August 31, 2011 10:47:00 AM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 9/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-09-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3537	Rev C
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100	0.00
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Waterjet	FLOW WATER JET
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FLOW CNC Waterjet	Memo
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341.063	I-Cut as per Dwg D3537 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary
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110	0.00
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Waterjet	FLOW WATER JET
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QC	Memo
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Quality Control	QC2- Inspect parts off machine FAI/FAIB
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110	0.00
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Waterjet	FLOW WATER JET
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QC	Memo
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Quality Control	QC2- Inspect parts off machine FAI/FAIB
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110	0.00
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QC	Memo
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Quality Control	QC2- Inspect parts off machine FAI/FAIB
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 73305

Wednesday, August 31, 2011 10:47:00 AM



Page 3

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 9/1/2011 Start Qty: 10.00

Required Date: 9/15/2011 Req'd Qty: 10.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00	5	ulor/26					

170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00	8	ulor/26					
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180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo	0.00	11:15	0.00	oven temperature:				
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W118489

320°F 11:45

14XØm-11/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73305

Wednesday, August 31, 2011 10:47:00 AM



Page 4

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 9/1/2011 Start Qty: 10.00

Required Date: 9/15/2011 Req'd Qty: 10.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							

14 ~~overst~~ 6 11/09/22

200 	Identify as per dwg & Stock Location:	F-P2	0.00
Packaging	Memo		0.00
Packaging			

14X Ø Mf 11/09/22

210 	QC21- Final Inspection - Work Order Release	0.00
QC Quality Control	Memo	0.00

11/09/22
MF
11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, August 31, 2011 10:46:56 AM

Work Order ID: 73305



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	129.1000	0.149	1.568421		B11-9-14	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020 118578	116.5 116.5	
MAT021 118217	12.6 12.6	

118578

(14)

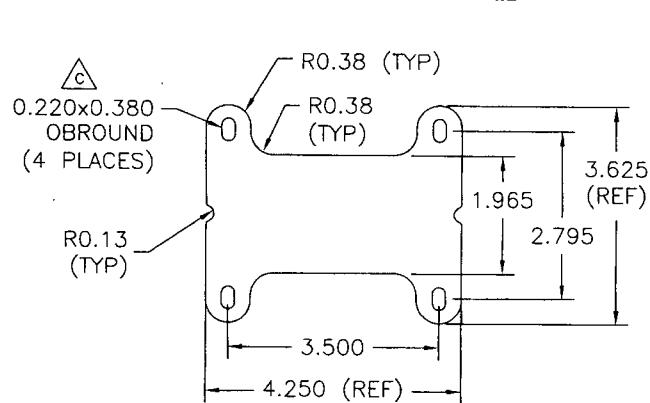
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

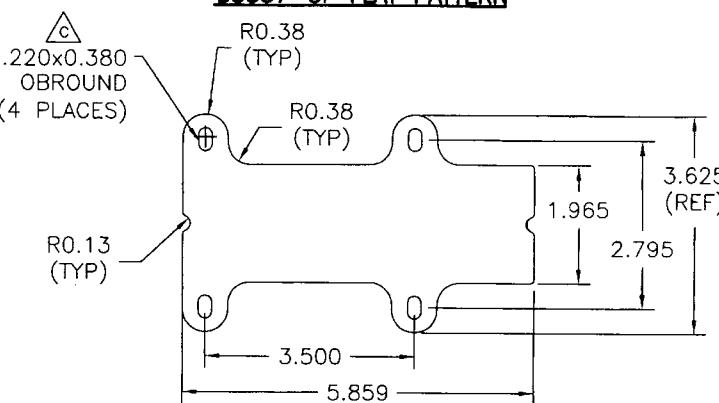
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

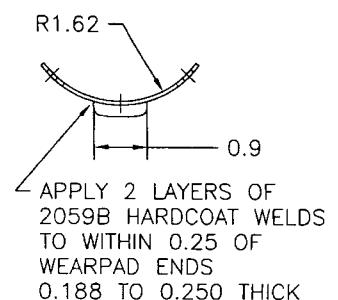
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

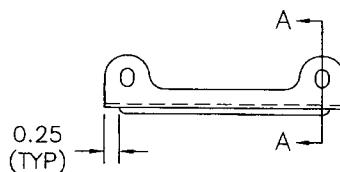


SECTION A-A



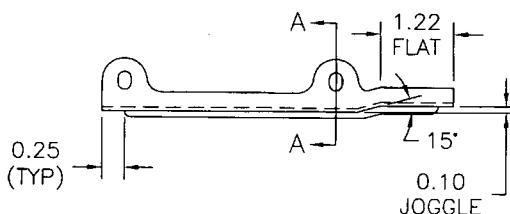
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



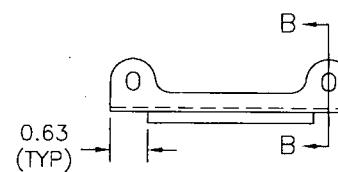
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND

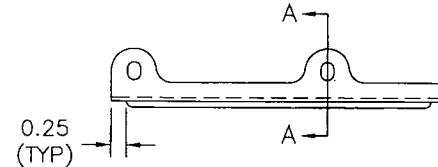
(MADE FROM D3537-1F)



RELEASER
07.05.08 AM
per ECR
962

D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
CHECKED	APPROVED	DRAWING NO. D3537 REV. C SHEET 1 OF 1
DATE	TITLE	SCALE
07.04.13	WEARPAD	1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73305
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>4-9-14</u>	Date: <u>11/05/14</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>✓</i>	<i>E</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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